

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000741**Date Inspected:** 31-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Huang Li & Zhu Zhonghai	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
		Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006	Component:	Caltrans Mockup	

Summary of Items Observed:

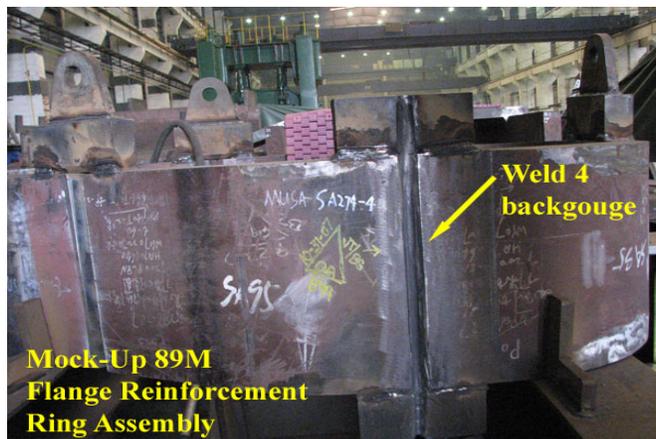
Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M and U-Rib Trial Assembly, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Flange Ring	NA	NA	Work in Progress

Mock-Up 77M, Flange Reinforcement Ring Assembly: Caltrans QA Inspector observed weld joint preparation after air carbon arc backgouging. ZPMC QC inspector, Mr. Xue Shen Jun notified Caltrans QA Inspector that a flange reinforcement ring, identified as SA274, weld #4, weld joint, is ready for inspection. QC stated that the weld joint has been inspected by QC and found to be acceptable. Caltrans QA Inspector observed that the weld joint has been ground to bright metal and the surfaces appear to be smooth, uniform and free of gouges. The weld joint appears to be in conformance with project specifications. Following digital picture illustrates backgouge preparation at the weld joint.

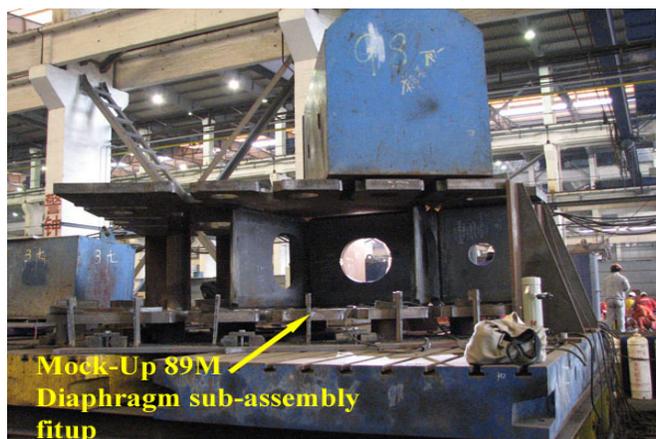
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2 Diaphragm Sub-Assy NA NA Fitup of Sub-Assy

Mock-Up 89M Diaphragm Sub-Assembly: Caltrans QA Inspector performed dimensional verification of the fitup of the top diaphragm plate assembly (SA13/p1236) joining web plates (p842, p138, p720, p721) to the bottom diaphragm plate assembly (p1235). The assembly was inspected for web fitup to the top and bottom diaphragm plates, distance between diaphragm plates and web locations. The dimensional variation between required dimensions and measured dimensions was 2mm and less. Following digital picture illustrates diaphragm assembly at the workstation.



Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
